

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-014503**Date Inspected:** 28-May-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 600**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1100**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site

CWI Name:	Bernard Docena, Bnifacio Daquing, W. P. Gumbayab			CWI Present:	Yes	No	
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A	Approved WPS:	Yes	No	N/A
				Delayed / Cancelled:	Yes	No	N/A
Bridge No:	34-0006			Component:	SAS OBG		

Summary of Items Observed:

The Quality Assurance (QA) Inspector, Rick Bettencourt was on site at the job site between the times noted above. The QA Inspector was on site to randomly observe the in process welding and inspection of the weld joints identified 2W/3W-E/C and the following observations were made:

2W/3W-E-2

The QA Inspector randomly observed the ABF welders had previously started the induction heating blankets to ensure the minimum required preheat of 150°F was achieved prior to welding. The QA Inspector randomly verified utilizing a 150°F temperature indicating marker and noted the minimum required preheat had been achieved. The QA Inspector observed the ABF welder to be utilizing a semi automated FCAW track system for welding the above identified weld joint. The QA Inspector randomly observed the Smith Emery (SE) QC Inspector identified as Jim Cunningham set the FCAW machine to the parameters of the approved WPS identified as ABF-WPS-D1.5-3042A-1. The QA Inspector randomly observed the FCAW parameters were 274 Amps, 21.7 Volts and a travel speed of 266mm/min. The QA Inspector randomly observed the ABF welder Jeremy Doleman continued the FCAW cover pass, once the semi automated track system reached a certain point the ABF welder Rory Hogan would observe the welding arc for the remainder of the weld. The QA Inspector noted the ABF welders did complete the section of weld in C2 on the QA Inspectors shift. The QA Inspector noted the entire weld joint was completed on this date.

2W/3W-C

The QA Inspector randomly observed the ABF welder identified as Bryce Howell performing plasma arc gouging of the above identified weld joint. The QA Inspector noted the weld joint back gouge appeared to be

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

approximately 50% at the end of the QA Inspectors shift.

Pipe Hinge K

Upon the arrival of the QA Inspector it was observed the first Pipe Hinge K arrived on the join site last night. The QA Inspector noted the Pipe Hinge K was off loaded in the am set on the ground at the under W2. The QA Inspector performed a random visual inspection and noted no visible damage appeared to be present from shipping. The QA Inspector noted the shipping tag from the METS personnel had been previously removed and was not present at the time of the QA Inspectors arrival.



Summary of Conversations:

As noted above.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mohammad Fatemi (916)-813-3677, who represents the Office of Structural Materials for your project.

Inspected By:	Bettencourt,Rick
----------------------	------------------

Quality Assurance Inspector

Reviewed By:	Levell,Bill
---------------------	-------------

QA Reviewer
